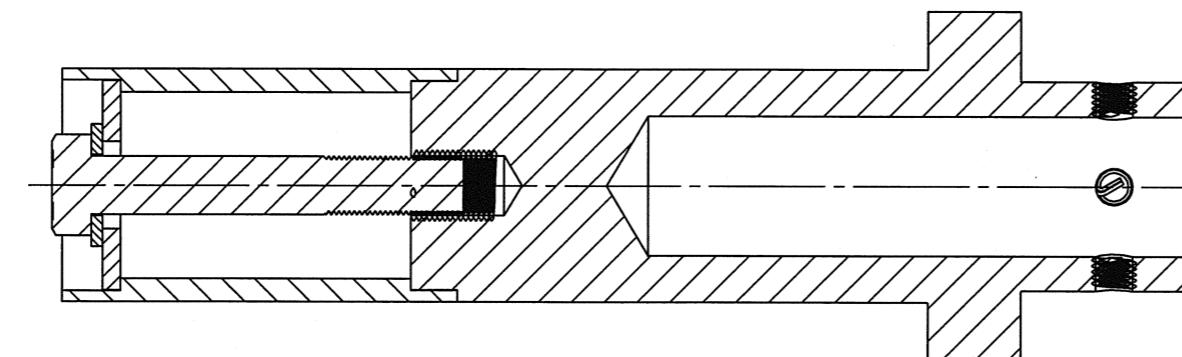
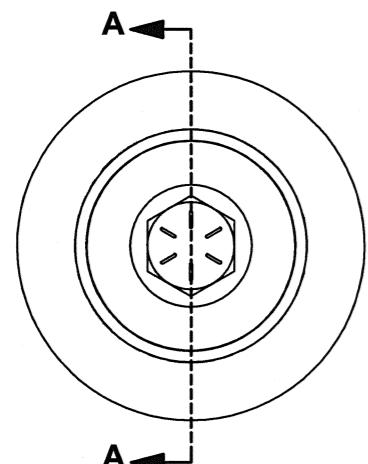
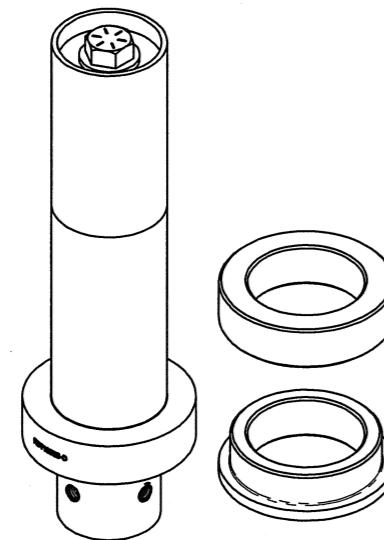


ITEM #	QTY	PART #	PART TITLE
-2	1	RBT18522-C-2	HUB ASSY
-3	1	RBT18522-C-3	TUBE WELDMENT
4	1	RBT18649-1-1	SLEEVE A
5	1	RBT18649-1-2	SLEEVE B
6	1	McMaster#91257A829 OR EQUIV	ZINC YELLOW PLATE STEEL GRADE 8 HEX HEAD SCREW 5/8"-18 X 4" LG.
7	1	McMaster#90126A035 OR EQUIV	ZINC PLATE STEEL FLAT WASHER FOR 5/8" SCREW SIZE 0.656" ID X 1.312" OD X 0.074"-0.121" THK



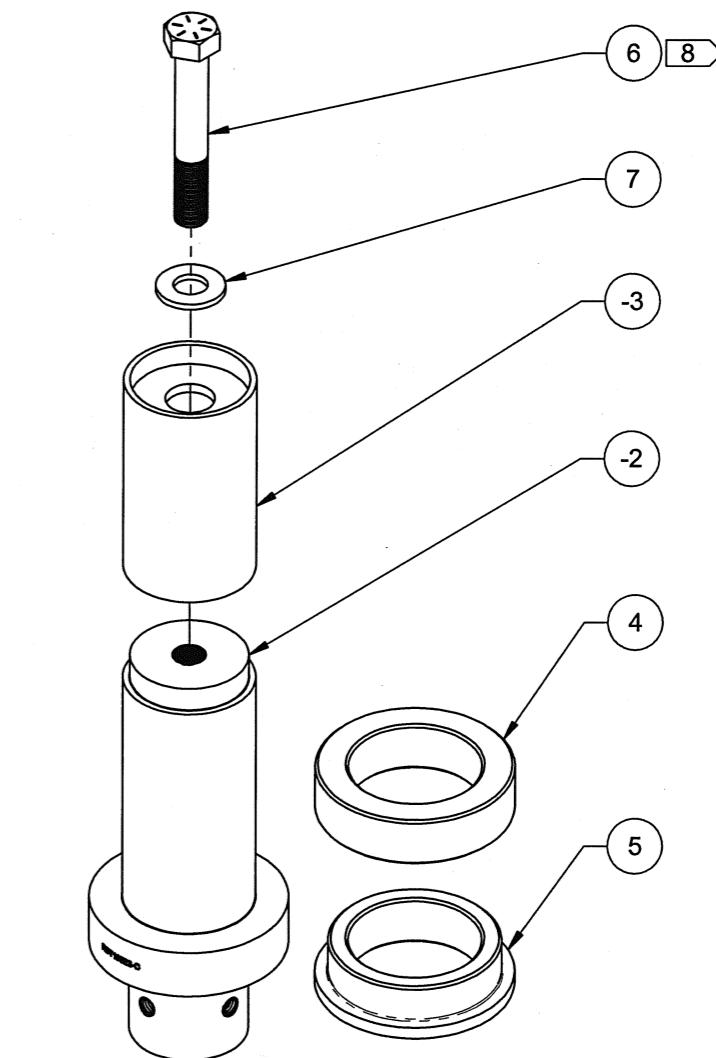
SECTION A-A

RBT18522-C 407 ADAPTER

9

NOTES:

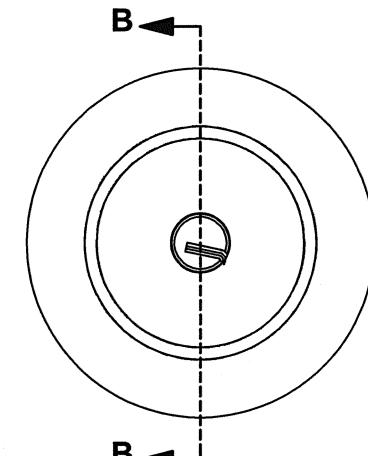
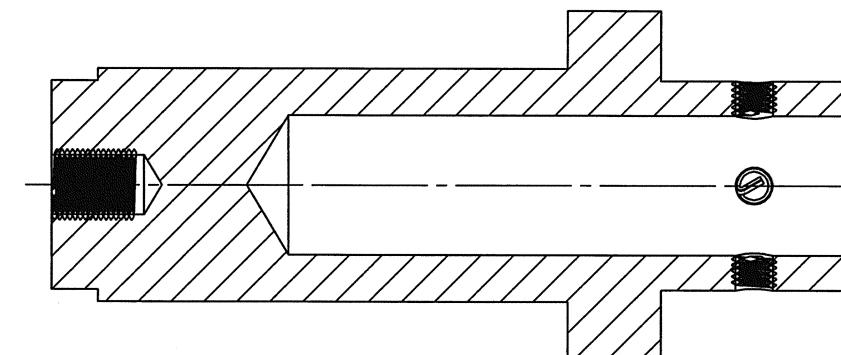
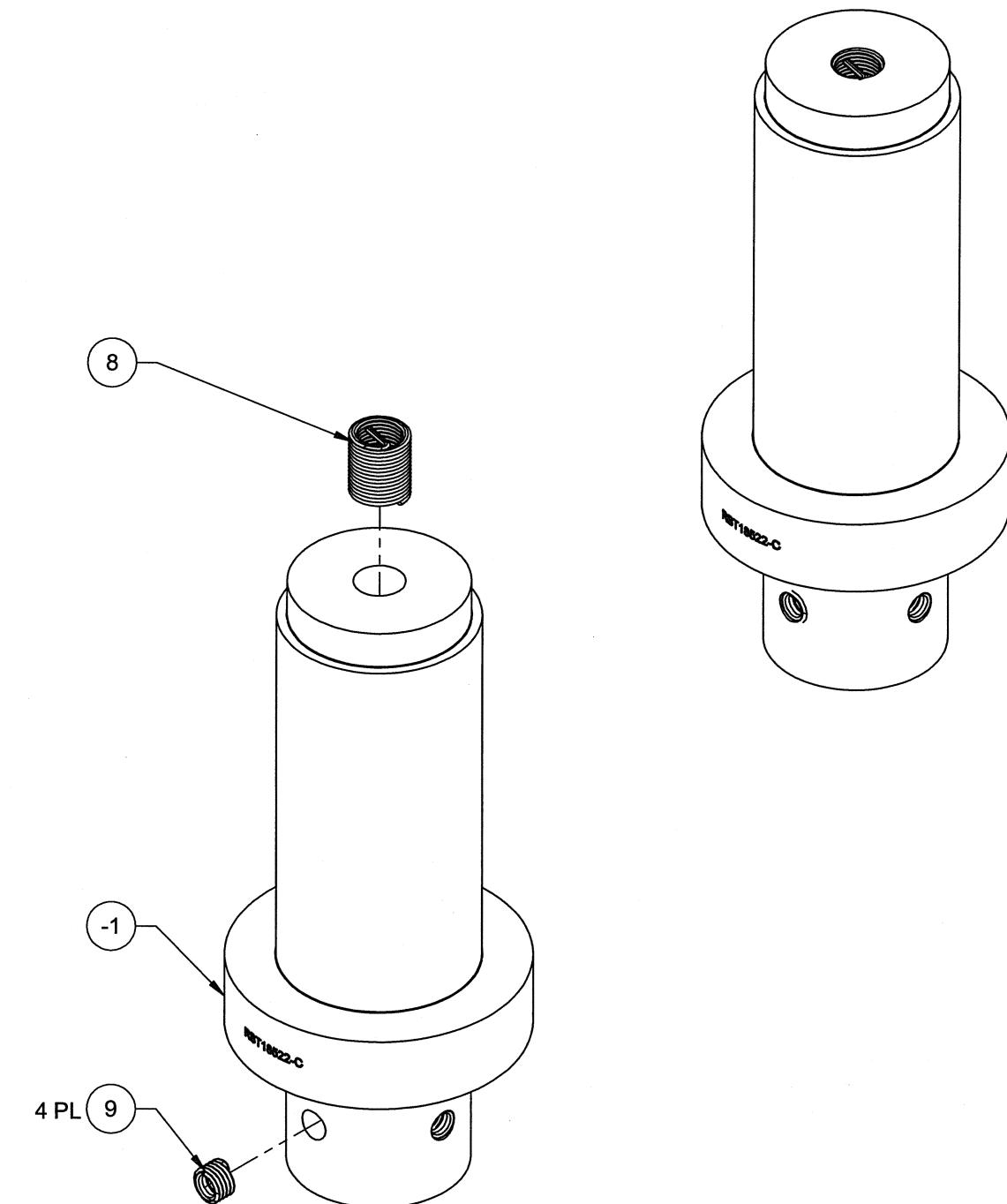
- 1) MATERIAL: N/A
- 2) HEAT TREAT: N/A
- 3) FINISH:
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) IDENTIFICATION: N/A
- 7) ASSEMBLE AS SHOWN
- 8) INSTALL ITEM 6 HAND TIGHT
- 9) THE TOOL ASSY MUST BE PACKAGED WITH A DESICCANT BAG INTO A TIGHT FITTING SEALED PLASTIC BAG



SEE PREVIOUS PDFs FOR OLD REVs TEMPLATE UPDATED PER DART HBY STANDARDS RBT18649-5 CHANGED FOR RBT18649-1-1 RBT18649-7 CHANGED FOR RBT18649-1-2 ITEM -9 McMaster#91247A444 CHANGED FOR ITEM 6 McMaster#91257A829 ITEM RBT18522-C-2 ASSY ADDED ITEM 8 AND ITEM 9 HELICOIL ADDED ITEM -1 MATERIAL 6061 CLEAR ANODIZE CHANGED FOR 6061/7075 RED ANODIZE, DIMENSION Ø1.5 V 6.0 CHANGED FOR Ø1.50 V 6.00, DIMENSION 4X 3/8-16 UNC -2B V .38 E.Q.S CHANGED FOR TAP FOR 3/8-16 HELICOIL V 0.75 4PL, ENGRAVING S/N AND "MADE IN USA" REMOVED, DIMENSION .50 CHANGED FOR 0.500 +0/-0.005, DIMENSION Ø2.25 +0/-0.01 CHANGED FOR 2.245 +0/-0.005, DIMENSION Ø2.240 CHANGED FOR 2.240 +0.005/-0, DIMENSION R0.008 MAX 3PL ADDED, DIMENSION Ø2.50 CHANGED FOR Ø2.500, DIMENSION 5/8- 18 UNF -2B V 1.00 CHANGED FOR TAP FOR 5/8-18 HELICOIL V 1.00 ITEM -3 WELDING SYMBOL CHANGED, FINISH ZINC PLATE TYPE I CHANGED FOR YELLOW ZINC PLATE TYPE 2 ITEM -5 MATERIAL DOM CHANGED FOR A513 TYPE 5 DOM TUBING, DIMENSION .50 CHANGED FOR 0.500 +0.005/-0, DIMENSION Ø2.250 CHANGED FOR Ø2.250 +0.005/-0, DIMENSION Ø2.260 CHANGED FOR Ø2.26 +0.01/-0, DIMENSION Ø2.480 CHANGED FOR Ø2.500			19-758	VM
REV.	DESCRIPTION		ECN #	BY
DESIGN	VM	DART AEROSPACE LTD		
DRAWN	VM	HAWKESBURY, ONTARIO, CANADA		
CHECKED	KPT	REV. G		
MFG. APPR.	JFC	SHEET 1 OF 5		
APPROVED	WP	TITLE 407 ADAPTER		
DATE 2019-06-03		SCALE	NTS	
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ITEM #	QTY	PART #	PART TITLE
-1	1	RBT18522-C-1	HUB
8	1	McMaster#91732A238 OR EQUIV	SS18-8 HELICAL INSERT 5/8"-18 X 0.938" LG.
9	4	McMaster#91732A376 OR EQUIV	SS18-8 HELICAL INSERT 3/8"-16 X 3/8" LG.

D

**RBT18522-C-2 HUB ASSY****SECTION B-B****NOTES:**

- 1) MATERIAL: N/A
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) IDENTIFICATION: N/A
- 7) ASSEMBLE AS SHOWN

DESIGN	VM	DART AEROSPACE LTD	
DRAWN	VM	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KPT	TOOL PART #	REV. G
MFG. APPR.	JFC	RBT18522-C	SHEET 2 OF 5
APPROVED	<i>[Signature]</i>	TITLE 407 ADAPTER	
DATE 2019-06-03		SCALE	NTS

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D

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C

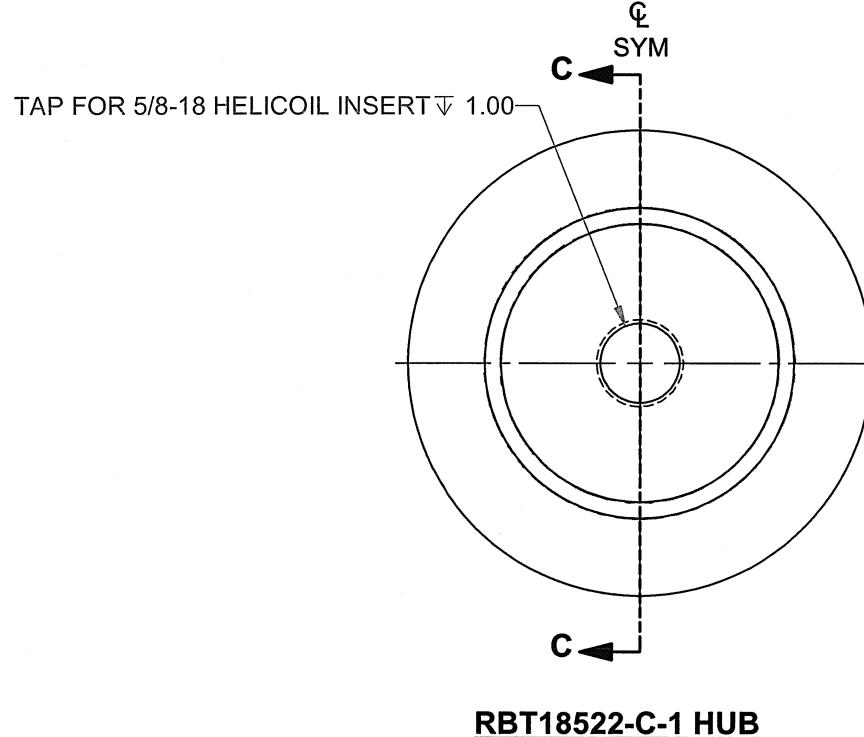
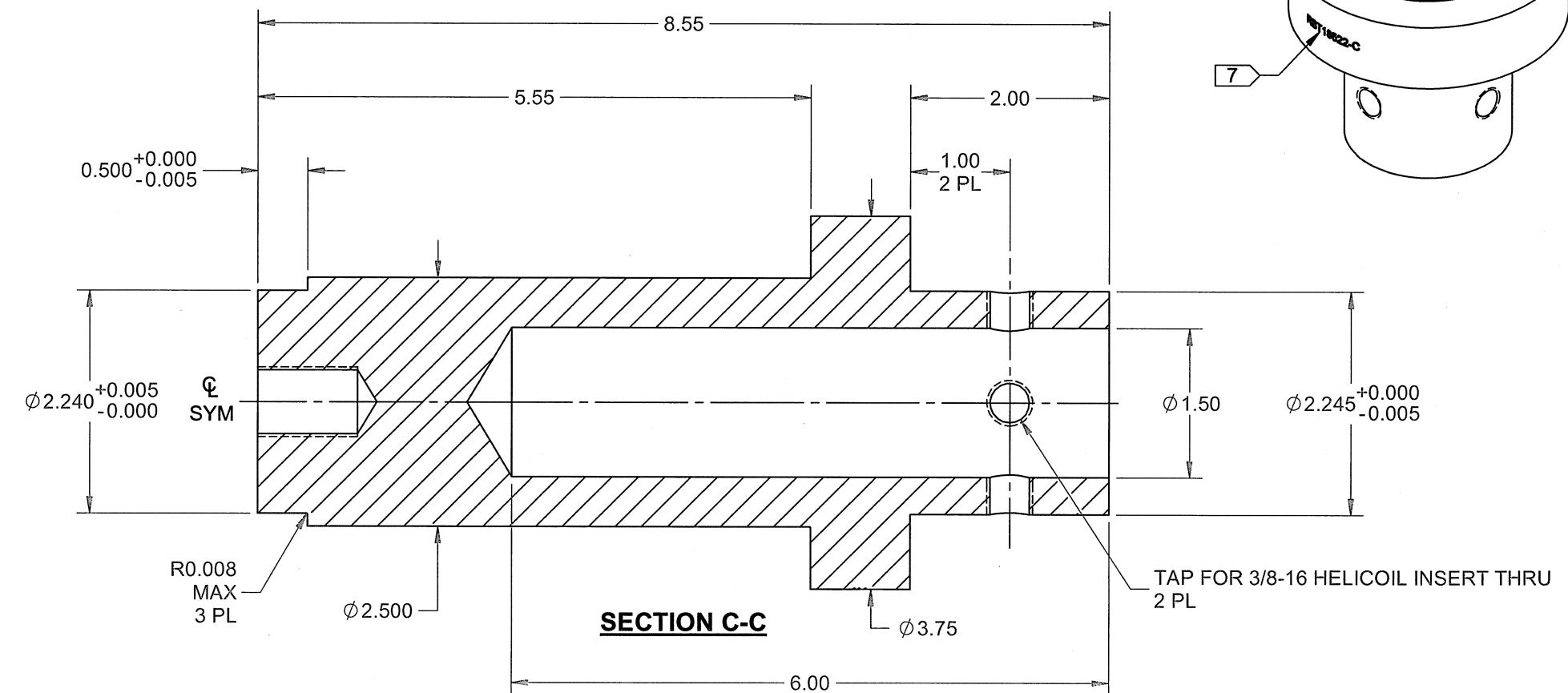
C

B

B

A

A

RBT18522-C-1 HUB

NOTES:

- 1) MATERIAL: 6061-T6 / 7075-T6
- 2) HEAT TREAT: N/A
- 3) FINISH: ANODIZE RED PER MIL-A-8625 TYPE 2 CLASS 2
- 4) TOLERANCES: X.X = $\pm 0.1"$ / $\pm 1^\circ$
 X.XX = $\pm 0.01"$ / $\pm 0.5^\circ$
 X.XXX = $\pm 0.005"$ / $\pm 0.1^\circ$
 X.XXXX = $\pm 0.0005"$ / $\pm 0.05^\circ$
 PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = $\pm 0.005"$
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: MACHINE ENGRAVE OR DOT MARK T/N, "RBT18522-C", AS SHOWN

DESIGN	VM	DART AEROSPACE LTD
DRAWN	VM	HAWKESBURY, ONTARIO, CANADA
CHECKED	KPT	
MFG. APPR.	JFC	
APPROVED	VJL	

TOOL PART # **RBT18522-C**

REV. G

SHEET 3 OF 5

SCALE NTS

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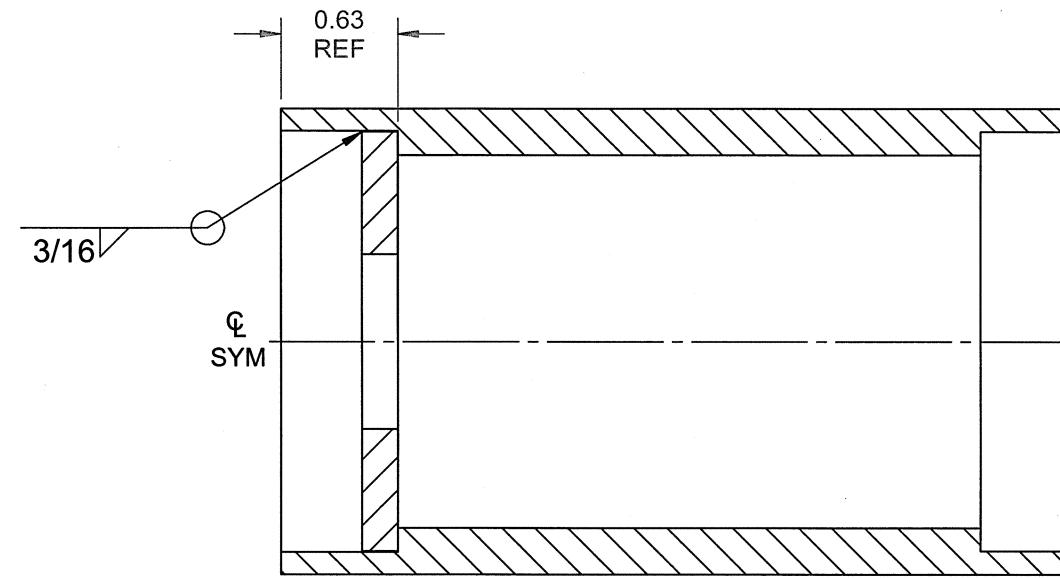
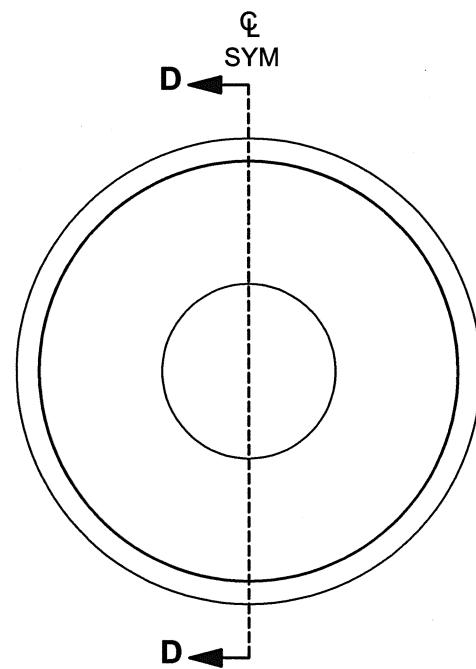
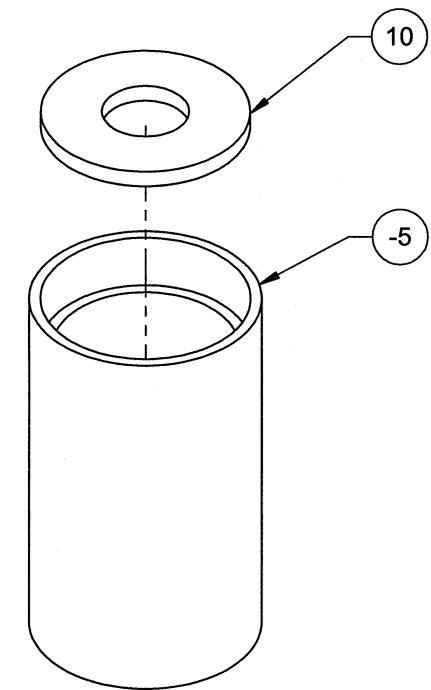
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DATE 2019-06-03

ITEM #	QTY	PART #	PART TITLE
-5	1	RBT18522-C-5	TUBE
10	1	McMaster#91081A037 OR EQUIV	STEEL USS FLAT WASHER FOR 7/8" SCREW SIZE 0.938" ID X 2.25" OD. X 0.136"-0.192" THK.

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**RBT18522-C-3 TUBE WELDMENT**

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C

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D

NOTES:

- 1) MATERIAL: N/A
- 2) HEAT TREAT: N/A
- 3) FINISH: ZINC PLATE (YELLOW OR BLACK) PER ASTM B633 TYPE 2 CLASS 2
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) IDENTIFICATION: N/A
- 7) ASSEMBLE AS SHOWN
- 8) REMOVE ALL WELD SPATTERS

DESIGN	VM	DART AEROSPACE LTD	
DRAWN	VM	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KPT		
MFG. APPR.	JFC		
APPROVED	<i>[Signature]</i>		
DATE 2019-06-03		TOOL PART #	RBT18522-C
		REV. G	SHEET 4 OF 5
		TITLE 407 ADAPTER	
		SCALE 	

NTS

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D

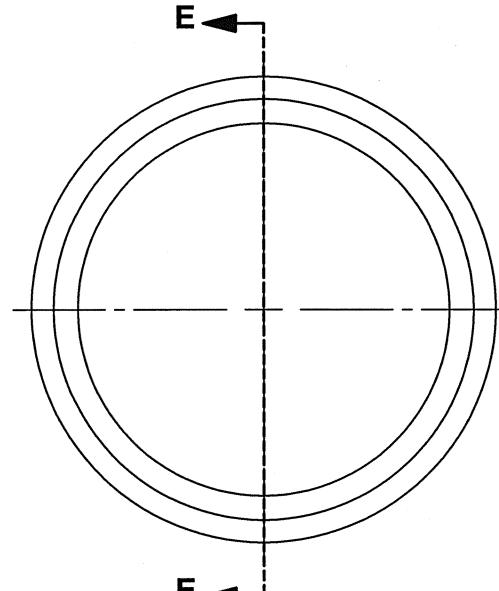
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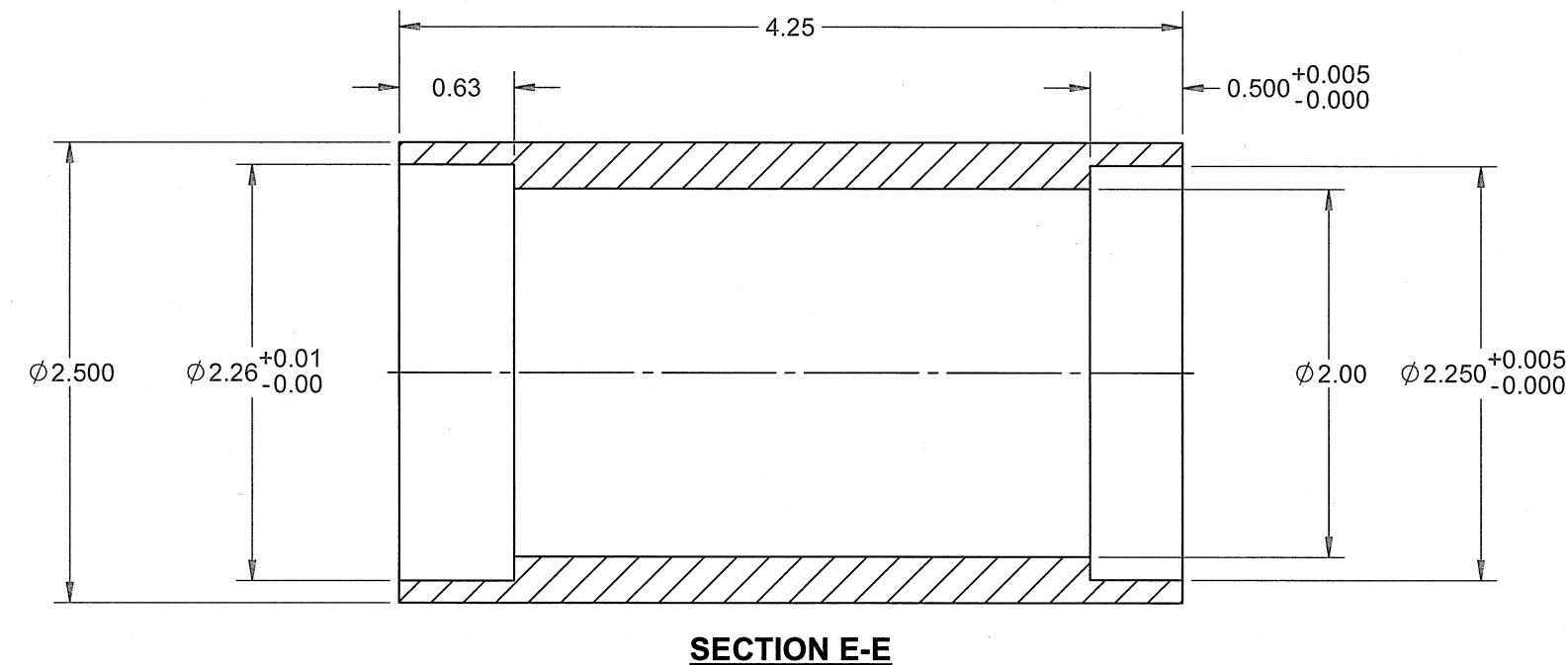
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RBT18522-C-5 TUBE



NOTES:

- 1) MATERIAL: A513 TYPE 5 DOM TUBING
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: N/A

DESIGN	VM	DART AEROSPACE LTD
DRAWN	VM	HAWKESBURY, ONTARIO, CANADA
CHECKED	KPT	REV. G
MFG. APPR.	JFC	SHEET 5 OF 5
APPROVED	<i>[Signature]</i>	DATE 2019-06-03
TOOL PART #		RBT18522-C
TITLE		407 ADAPTER
SCALE NTS		

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